

Date: Friday, 3/24/2006 2:25:36 PM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 26345 -1
 Estimate Number : 10145
 P.O. Number : N/A Part Number : D2037101
 This Issue : 3/24/2006 S.O. No. : N/A Drawing Number : D2037 REV C3
 Prsht Rev. : NC Project Number : N/A
 First Issue : 3/23/2006 Type : SMALL /MED FAB Drawing Revision : C3
 Previous Run : 24160A03 Material : N/A
 Due Date : 3/30/2006 Qty: 20 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.03.24
 Comment : Est Rev:A New Issue 05-11-01 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 4.1118 f(s)/Unit Total: 41.1180 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
 Batch: M100423(3x) / M100540(5x)

FF 06.04.03 19

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

FF 06.04.03 19

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

FF 06.04.03 9

2-Flatten ends of D2037-101 tube as required using DT8545

FF 06.04.04 9

3-Deburr as required

FF 06.04.04 9

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.04.04

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

CPL 06.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 26345

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc/04/13 (9)

Job Completion



u Doc/04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

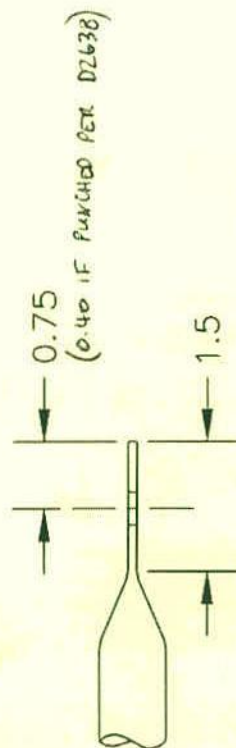
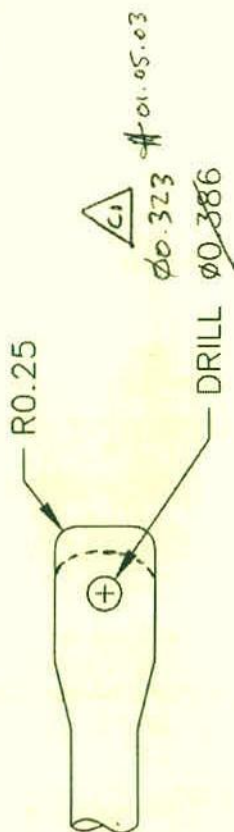
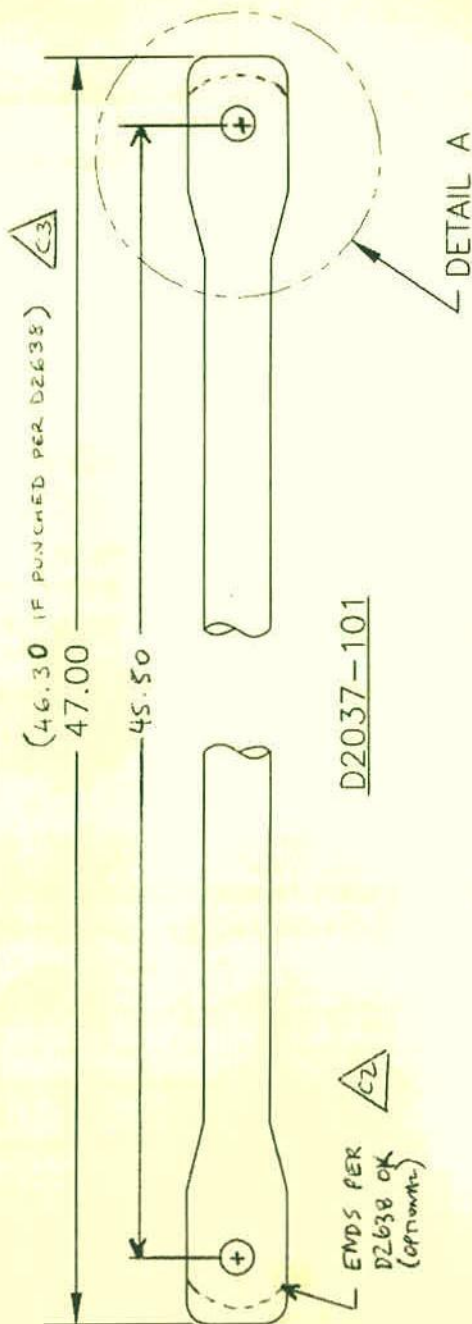
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07	TITLE ARM	SCALE NTS	
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	# CP 01.05.03	CHANGE TO $\phi 0.323$	
C2	# CP 02.06.14	ADD PUNCH PER D2638 AS OPTION	

**RELEASED**
KE 99.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26345

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 # 05.04.27 ADD 46.30 PUNCHED PER D2638

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries